

Work Order ID 75563***75563***

Page 1

Tuesday, October 25, 2011 11:48:56 AM

Item ID: D412-742-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 10/25/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/31/2011 Req'd Qty: 1.00

1

Customer:

Reference:

U/R***NS2***11/10/26
BASED
ON
ATTACHED
EMAIL

Approvals:

Process Plan:

mk

Date: 11-10-25

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

H U/R

100

0.00

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004*N/A*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75563

Page 2

N900040100

Setup Start *NS1*

Stop . *NS2*

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

110

HandFinishing

0.00

HandFinish

Hand Finishing

Memo

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/RSikaflex-241/-291 111 119299

Expiry date: 12/13 ⁰⁰

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,and tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 1/1 119299

Expiry date: 12/08/

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/RLPS Procyon 1114596

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NOTE: Date & initial all entries

Work Order ID 75563

75563

Page 3

Tuesday, October 25, 2011 11:48:56 AM

Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Float Skidtube
Start Date: 10/25/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/31/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-043								
	Location: _____								
	PPP Rev: <u>PPP 755600</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Rev D.

11/11/01

mf 11-11-01

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 25, 2011 11:48:56 AM

Page 1

Work Order ID: 75563

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 10/25/2011

Required Date: 10/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A05.10.13New Issue KJ/JLM
 IPP Rev B06.02.13ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A BOLT		Purchased	No			110	Each	2,547.0000	24	24		11/10/13	
----------------	--	-----------	----	--	--	-----	------	------------	----	----	--	----------	--

Location	Loc Qty	Loc Code
ST350	2547	
117313	2	
117688	5	
117872	22	
118112	16	
118451	2	
118706	500	
118838	1000	
119328	1000	

AN3C6A BOLT		Purchased	No			110	Each	224.0000	12	12		11/10/13	
----------------	--	-----------	----	--	--	-----	------	----------	----	----	--	----------	--

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	223	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	168	

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Page 2

Work Order ID: 75563

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 10/25/2011

Required Date: 10/31/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 147.0000
BOLT

8 HL 8 11/10/31

Location	Loc Qty	Loc Code
ST351	147	
113149	14	
116169	1	
117313	10	
117619	12	
117688	34	
118422	76	

AN960C10L washer Purchased No

110 Each 0.0000

44 1118354 (x44) HL 44 11/10/31

D3391-021 Fwd Tube Assembly Manufactured No

110 Each 0.0000

371455 (x1) HL 11/10/31

D3391-023 Mid Tube Assembly Manufactured No

110 Each 0.0000

371466 (x1) HL 11/10/31

D3391-025 Aft Tube Assembly Manufactured No

110 Each 0.0000

373016 (x1) HL 11/10/31

D3564-1 Wearshoe Manufactured No

110 Each 8.0000

1 HL 1 11/10/31

Location	Loc Qty	Loc Code
FG	2	
33798	2	
FP019	6	
72508	6	

D3564-3 Wearshoe Manufactured No

110 Each 14.0000

1 HL 1 11/10/31

Location	Loc Qty	Loc Code
FG	2	
33764	2	
FP	9	
71656	9	
FP019	3	
64748	3	

Tuesday, October 25, 2011 11:48:56 AM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 75563

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 10/25/2011

Required Date: 10/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 110 Each 16.0000
Wearshoe

1 ju 1 u/10/31

Location	Loc Qty	Loc Code
FG	2	
34806	2	
FP19	14	
<u>73330</u>	14	

D3566-1 Manufactured No 110 Each 45.0000
Gasket

2 ju 2 u/10/31

Location	Loc Qty	Loc Code
FP002	43	
<u>73303</u>	17	
74518	26	
FP015	2	
68924	2	

x2

D3566-5 Manufactured No 110 Each 36.0000
Gasket

1 ju 1 u/10/31

Location	Loc Qty	Loc Code
FP002	34	
74387	12	
75069	22	
FP015	2	
<u>72849</u>	2	

x1

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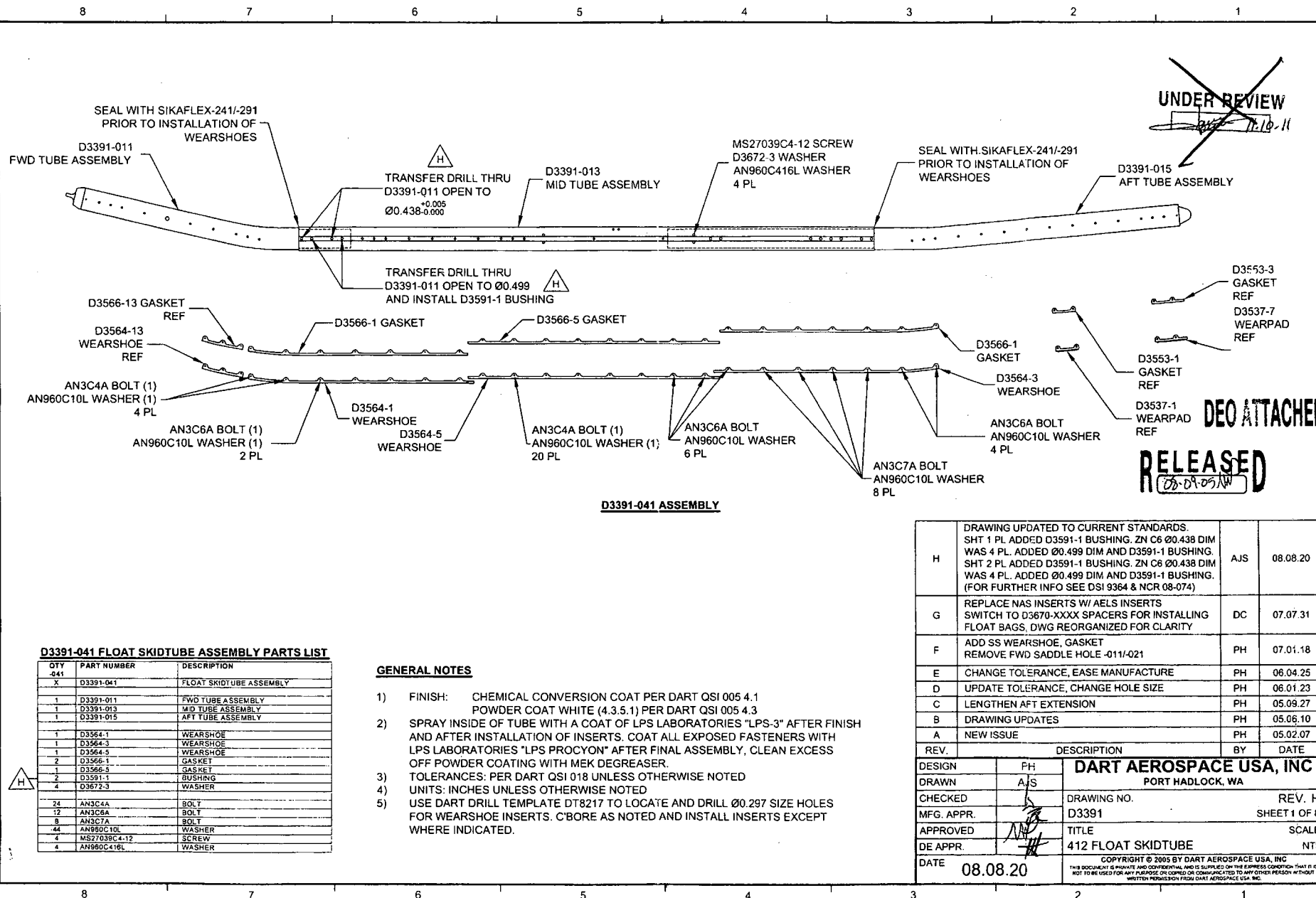
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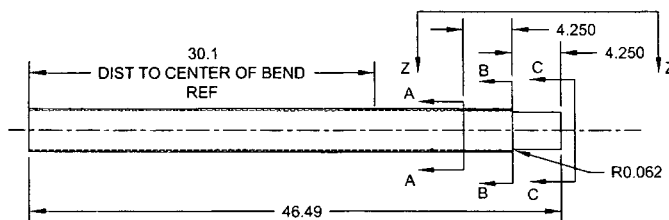
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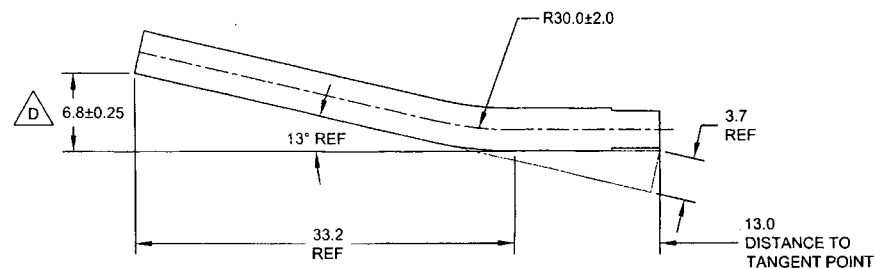
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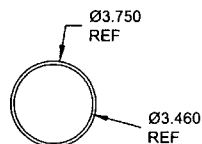
NOTE: Date & initial all entries



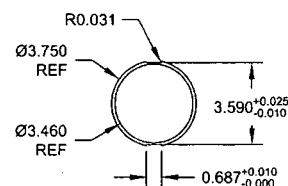
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



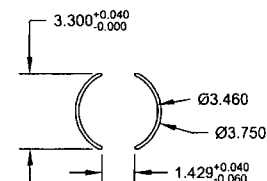
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



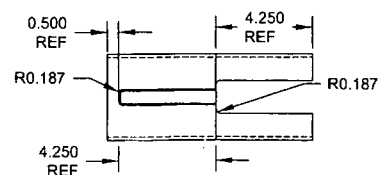
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

UNDER REVIEW
[Signature] 11.10.11

DEO ATTACHED
RELEASED
[Signature] 08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

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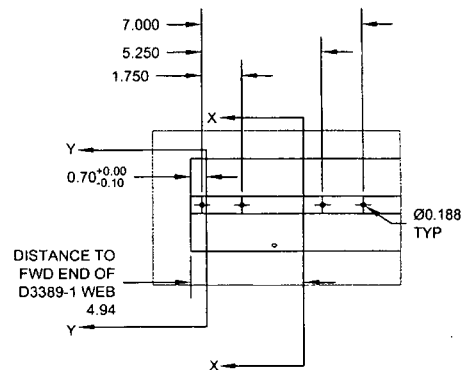
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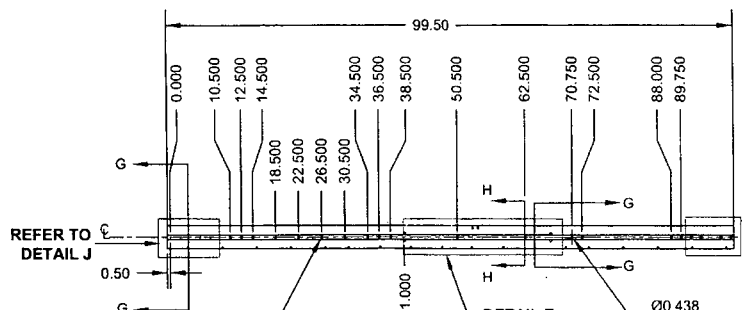
NOTE: Date & initial all entries

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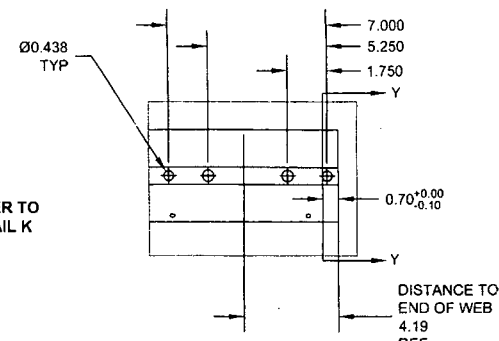


DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



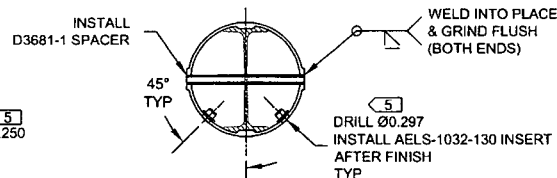
D3391-013 ASSEMBLY DETAIL



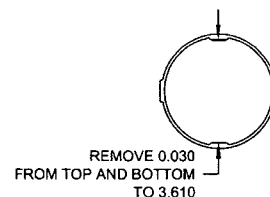
DETAIL K
SCALE 4X



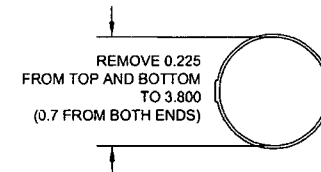
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X

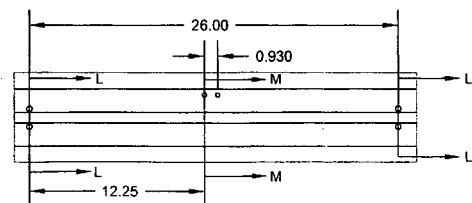


SECTION Y-Y
SCALE 5X

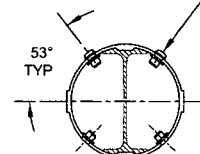
UNDER REVIEW
11/18/11

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

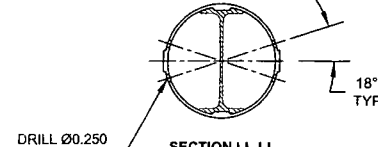


DETAIL E
SCALE NONE



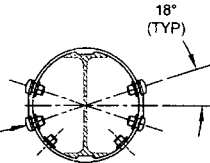
SECTION M-M
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



SECTION LL-LL
SCALE 5X

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



SECTION L-L
SCALE 5X

DEO ATTACHED

RELEASED
08/08/20

D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-2411/291 PER QSI 015
- WELDING: PER DART QSI 004

DESIGN	FH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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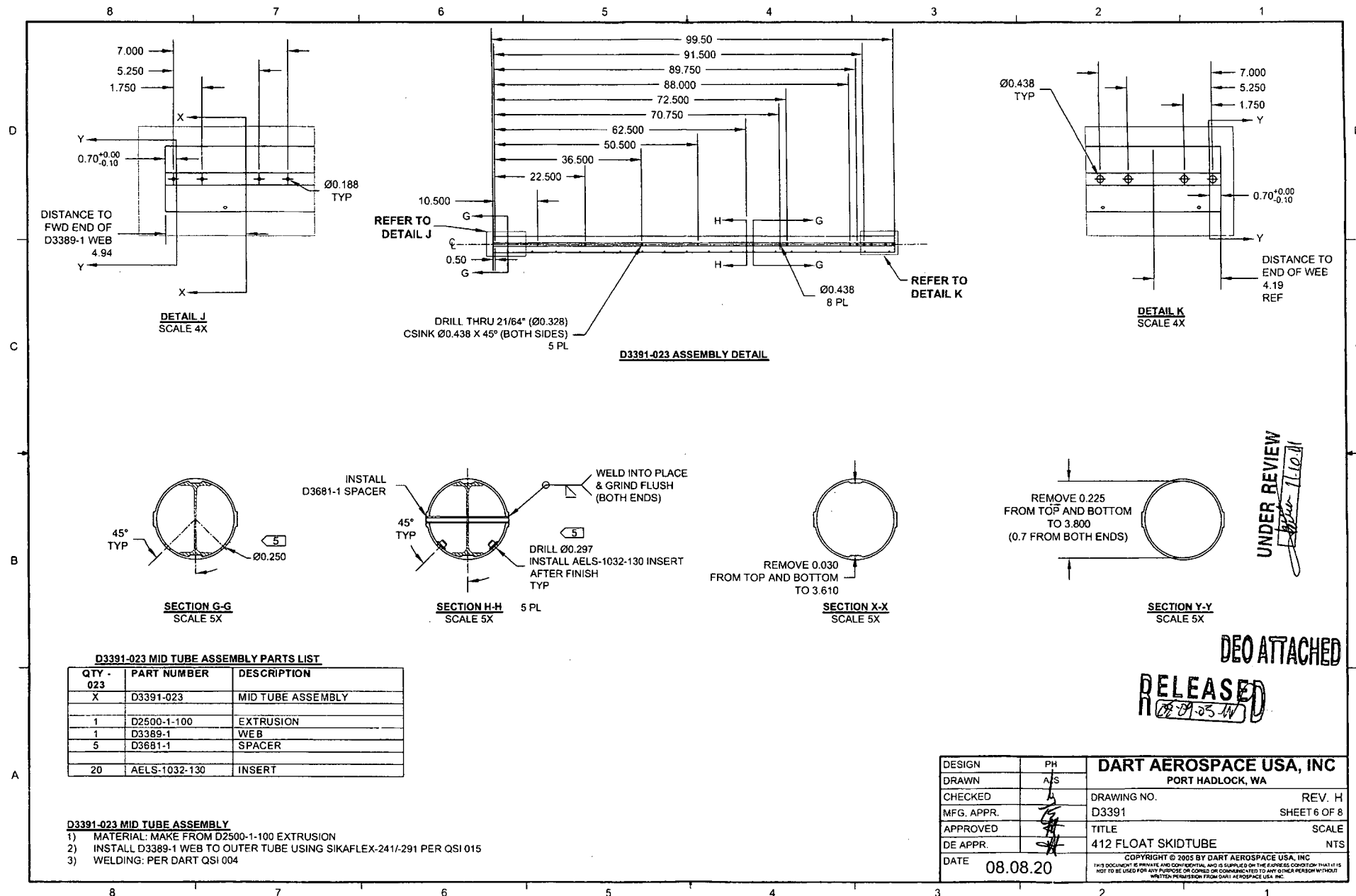
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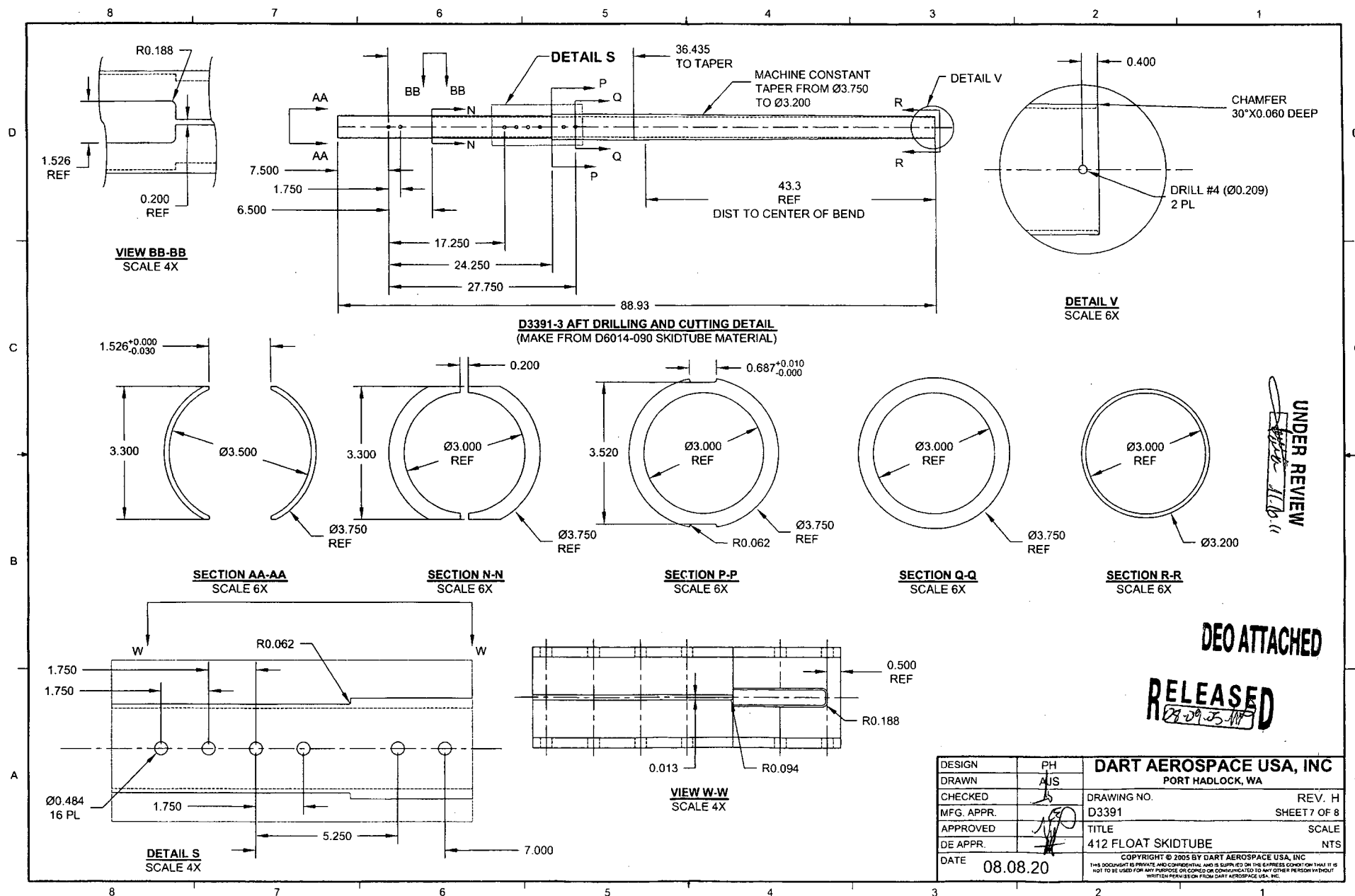
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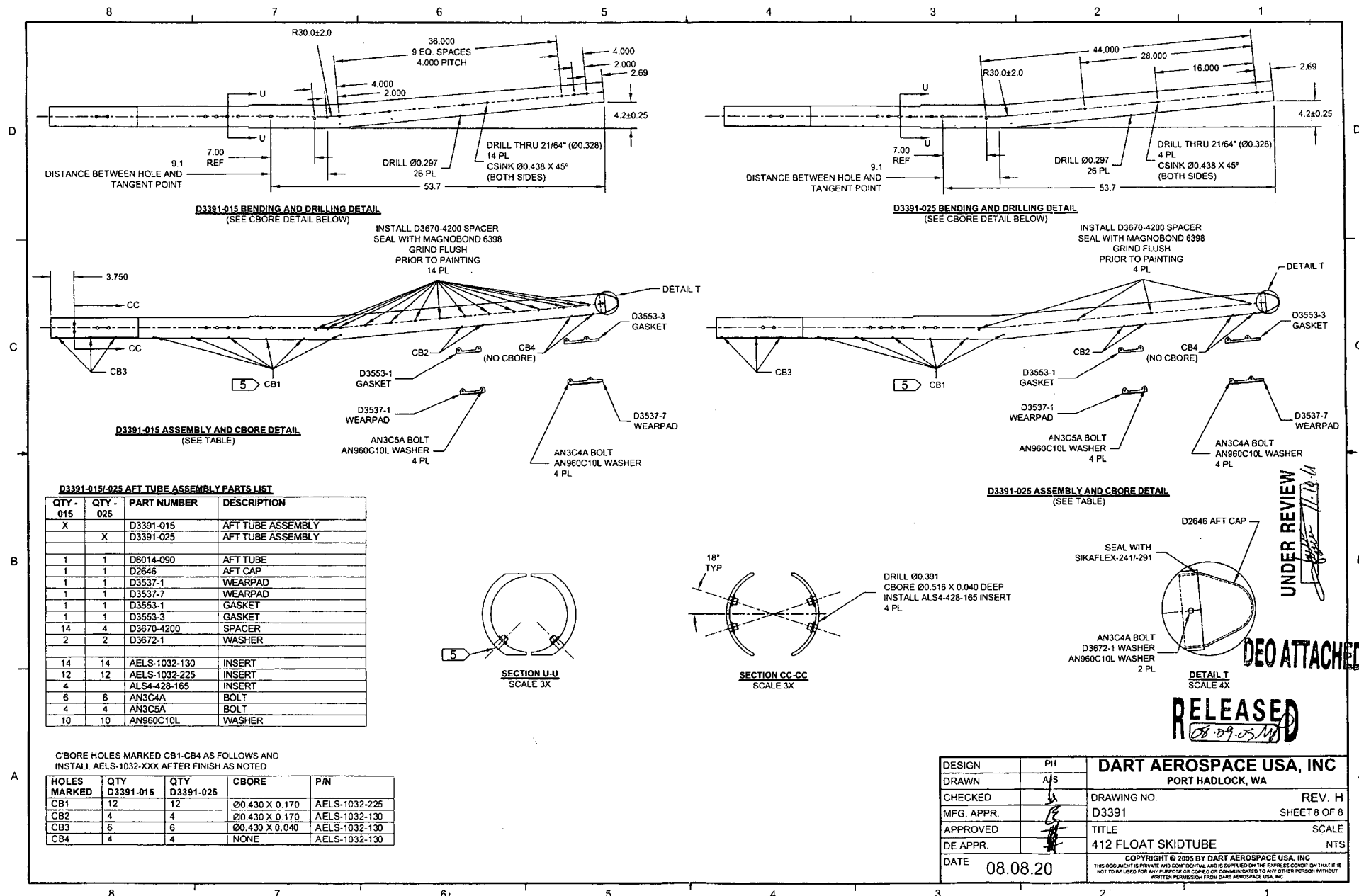
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 06.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02
MP

UNDER REVIEW

PER PAR 11-125

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Mike Petsche

From: Linda Lacelle <llacelle@dartaero.com>
Sent: Thursday, October 27, 2011 5:06 PM
To: 'Mike Petsche'; dshepherd@dartaero.com
Subject: FW: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

fyi

From: Shirley Hay [<mailto:SHay@darths.com>]
Sent: October-27-11 3:55 PM
To: Linda Lacelle; Nancy MacLeod; sbedford@dartaero.com; mfauteux@dartaero.com; 'Brigitte Golden'; rmolnar@dartaero.com
Cc: Linda Pilon; Carole O'Rourke; Carrie Pearson
Subject: RE: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

Hello

Please send out the old configuration

Regards
Shirley Hay

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: Wednesday, October 26, 2011 3:34 PM
To: Nancy MacLeod; sbedford@dartaero.com; mfauteux@dartaero.com; 'Brigitte Golden'; rmolnar@dartaero.com
Cc: Linda Pilon; Shirley Hay; Carole O'Rourke; Carrie Pearson
Subject: RE: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

There has been a recent engineering change on the float skids, and the earliest we can ship these would be the week Nov. 7th, or we ship the current CHG number with the old configuration of wearplates...please let mw know how you would like to proceed.

Linda

From: Nancy MacLeod [<mailto:NMacLeod@darths.com>]
Sent: October-20-11 1:56 PM
To: 'sbedford@dartaero.com'; 'llacelle@dartaero.com'; 'mfauteux@dartaero.com'; Brigitte Golden; rmolnar@dartaero.com
Cc: Linda Pilon; Shirley Hay; Carole O'Rourke; Carrie Pearson
Subject: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

Please see the attached PO for Bristow US LLC.

If you require any further information, please let me know. Thank you,